

SWP CN 07214 18 05 001

A9B10142849

SWP: 西门子风电

CN:中国 (零件运往何处)

07214:飞跃代码

18:生产年份(根据实际生产年份)

05:生产月份(根据实际生产月份)

001: 序号从001-999

A9B10142849: 零部件物料号

字体高度10mm

Note 1: All dimensions are in mm.

Note 2: In case of conflict between requirements of 2D-drawing and any received reference 3D file or DXF file, then the requirements on the 2D-drawing shall prevail

Note 3: General tolerances:

For unspecified measurements, the tolerance classes listed hereafter apply.

The tolerances for linear dimensions: Tolerance class A according to ISO 13920:1996;

The tolerances for angular dimensions: Tolerance class A according to ISO 13920:1996


Tolerances for straightness, flatness, and parallelism: Tolerance class E acc. to ISO 13920:1996.

Note 4 Modifications from previous revisions are indicated with the symbol Δ or a "Revision cloud" and the

symbol Δ		

Pos	Qty	Dimension	Alt. Dim. 1	Alt. Dim. 2	Mat. req.	Purch. spec.	Mass
1	1	IPB 900-DIN 1025-2			S355J2 UT 1, 2/2,4	Gr. 2.1 ZPS 1009554	1713,6kg
2	1	PI 160 mm.			S355NL UT S3/P	Gr. 2.2 ZPS 1009554	248,6kg
3	1	PI. 15 mm.			S355J2	Gr. 2.1 ZPS 1009554	9,7kg

Weight app.:	1970.4 kg	Proprietary class:	Restricted	EC 3
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Part:	Main beam for Rear End D6 - 7,0	Draw. format:	ISO	Draw. scale	Sheet no.:
		A1		1:20	1/5

富都机械

ECN No.:	Revision:
000000	000

233078 006

Design ID:
D1143230

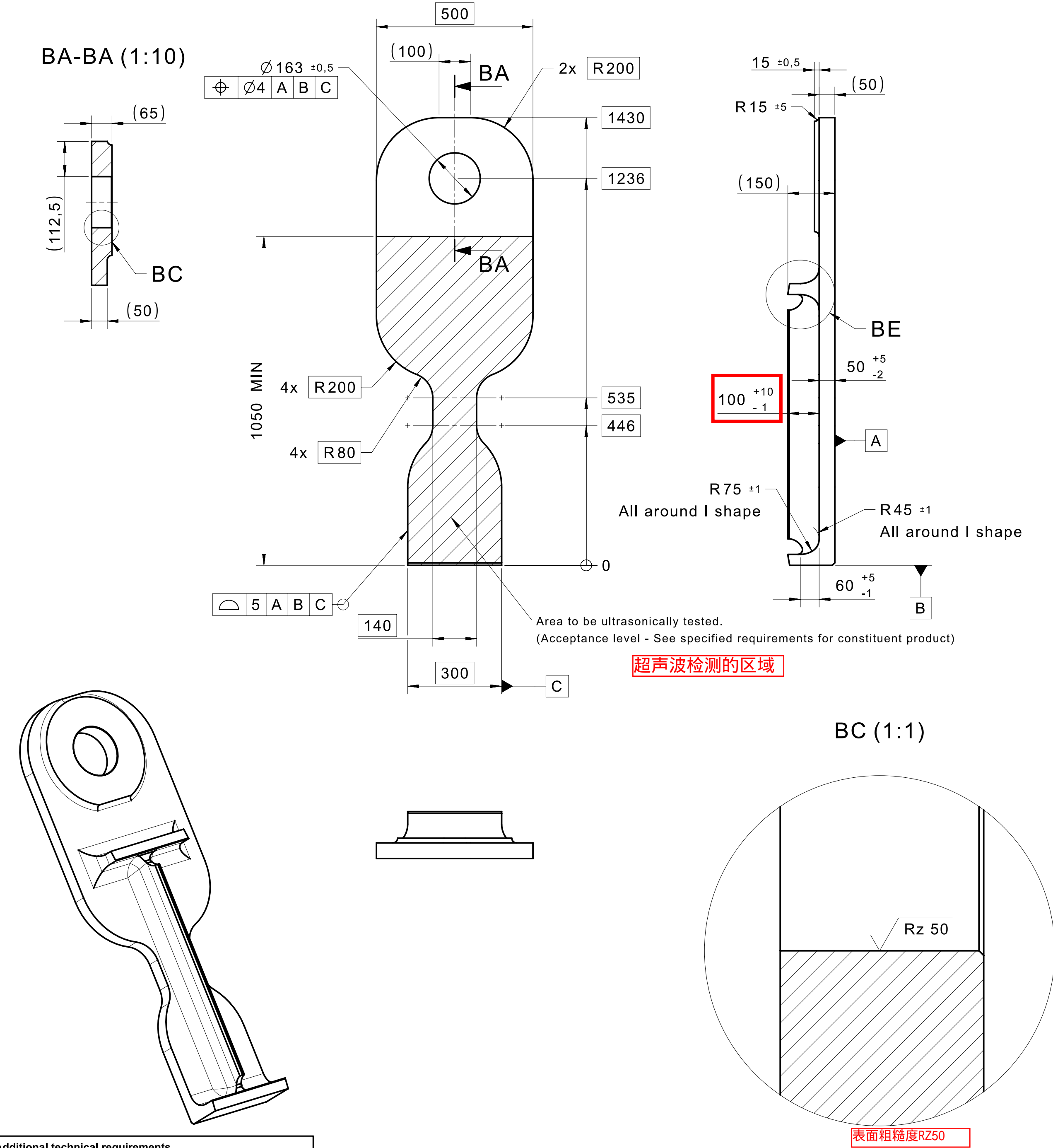
D1143239

A9B10142849

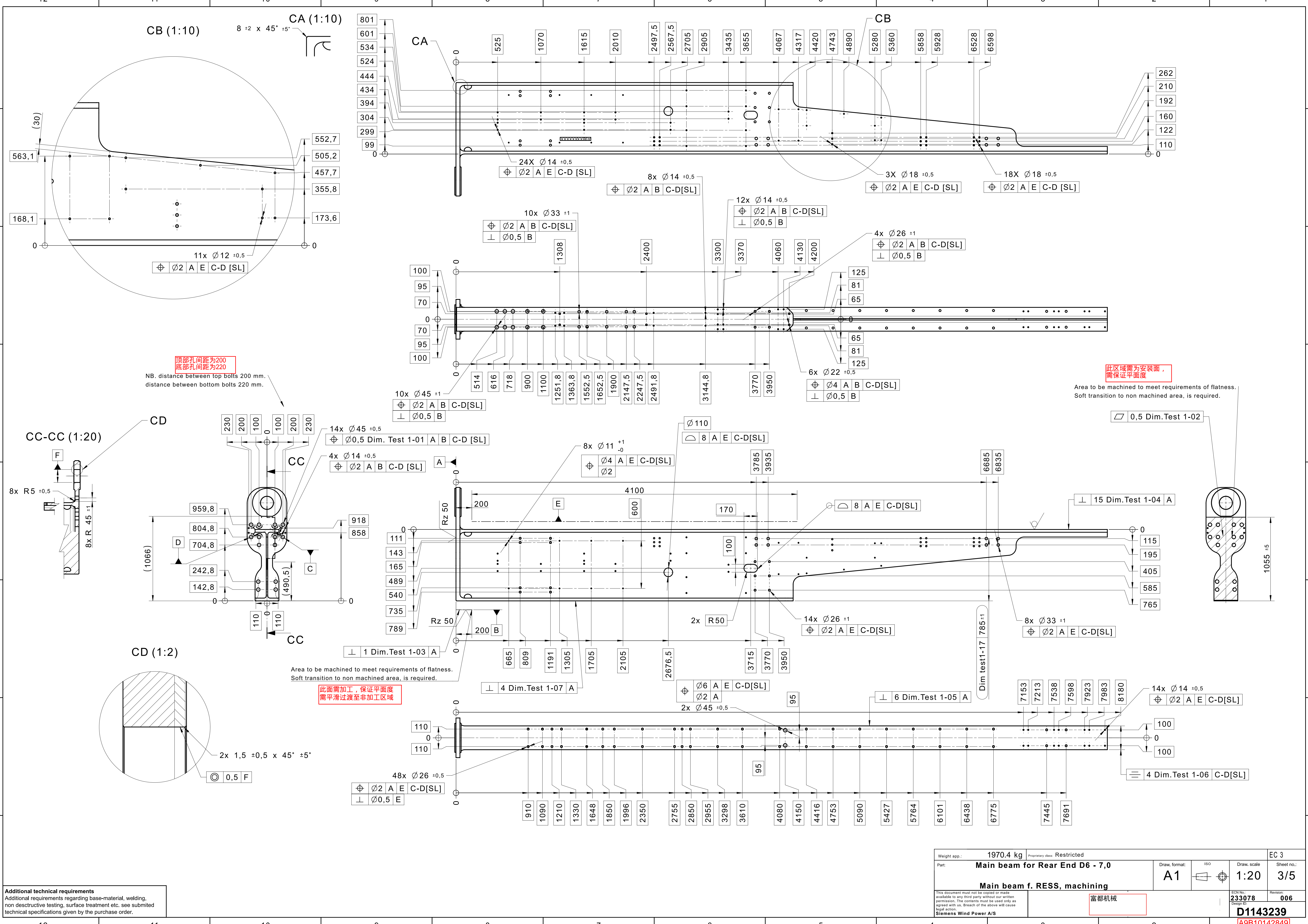
Additional technical requirements
Additional requirements regarding base-material, welding, non destructive testing, surface treatment etc. see submitted technical specifications given by the purchase order.

富都机械

Machined part POS 2 (1:10).



Weight app.:	1970.4 kg	Proprietary class: Restricted	EC 3
Part:	Main beam for Rear End D6 - 7,0		Sheet no.: 2/5
Draw. format: A2		Draw. scale: 1:10	Revision: 006
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Siemens Wind Power A/S		富都机械	A9B10142849



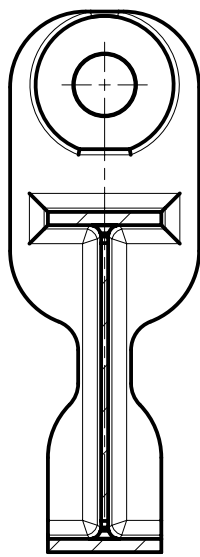
Additional technical requirements
Additional requirements regarding base-material, welding, non destructive testing, surface treatment etc. see submitted technical specifications given by the purchase order.

Weight app.: 1970.4 kg	Proprietary class: Restricted	EC 3
Part: Main beam for Rear End D6 - 7,0	Draw. format: A1	Sheet no.: 3/5
Main beam f. RESS, machining	1:20	Revision: 006
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Siemens Wind Power A/S		D1143239
		A9B10142849

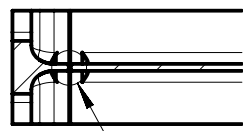
Welding Assembly

Note Q-1 Welding symbols according to ISO 2553:1992

WA-WA (1:20)

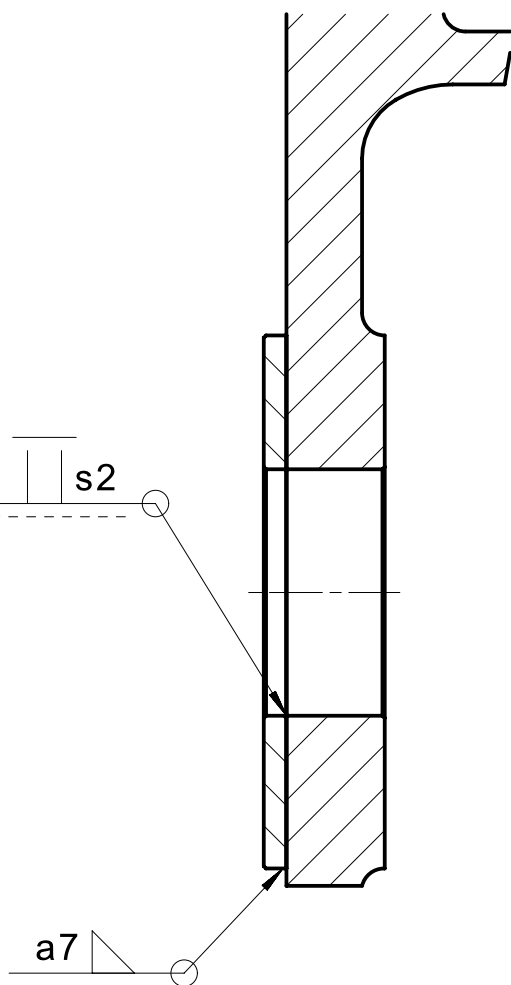


WB-WB (1:20)

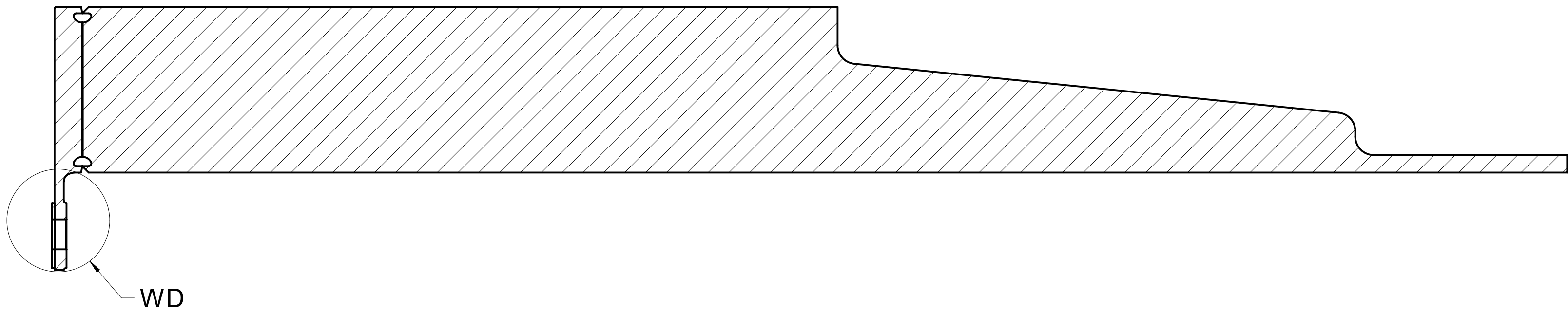


WF

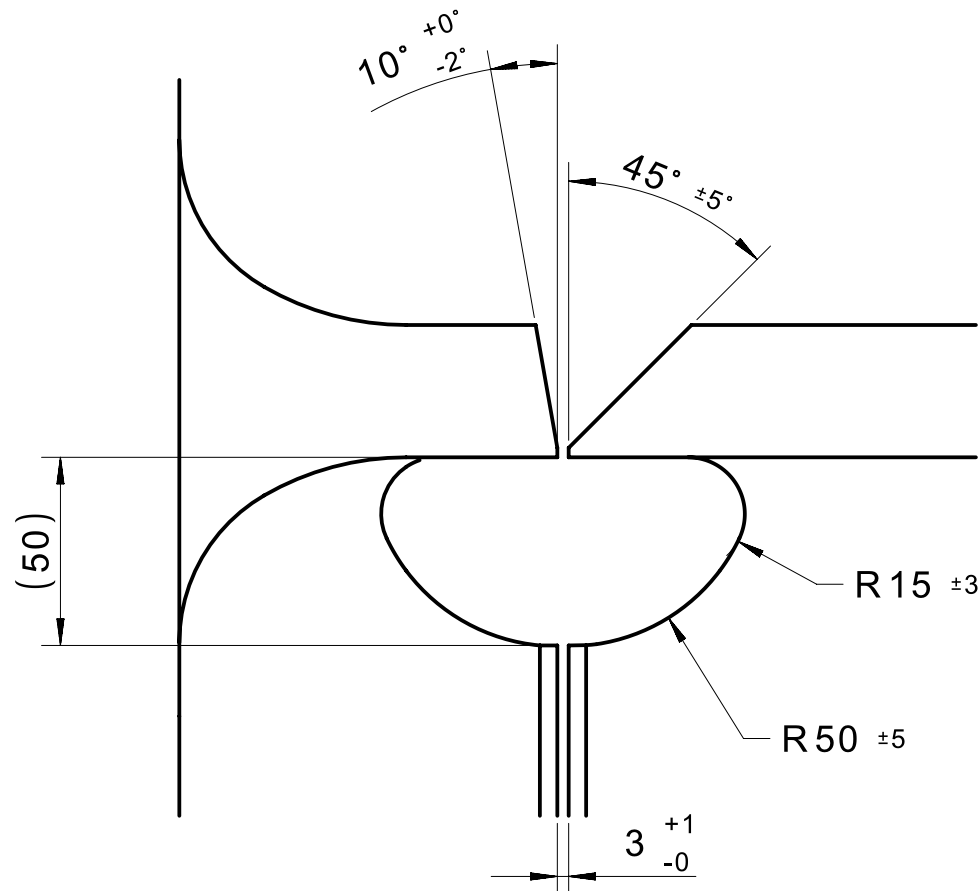
WD (1:5)



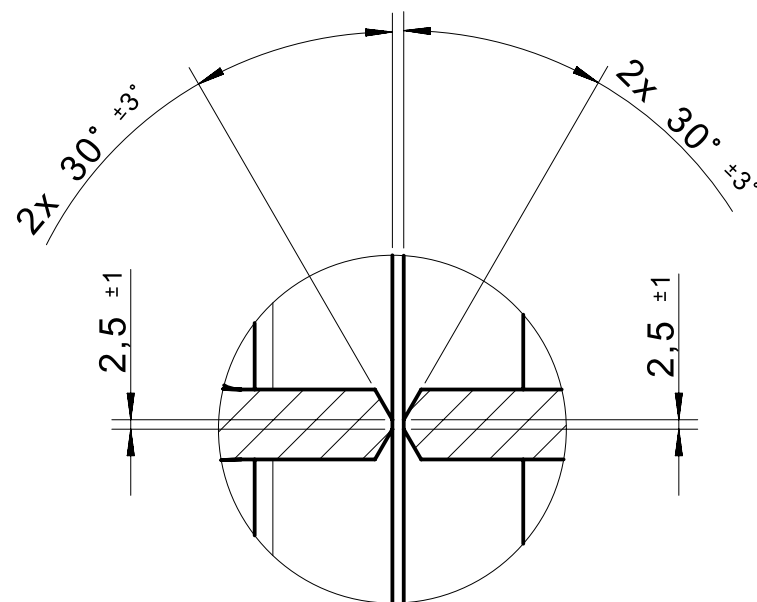
WC-WC (1:20)



WE (1:2)



WF (1:2)



Note 1: Area to be machined after welding
Note 2: Before welding of the profile (POS 1) IBP 900-DIN 1025-2 to the machined end plate (POS 2) it must be ensured that the end of the profile (POS 1) to be welded, has been tested for internal soundness, according to the specification.

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Weight app.: 1970.4 kg		Proprietary class: Restricted		EC 3	
Part: Main beam for Rear End D6 - 7,0		Draw. format: A1	ISO	Draw. scale: 1:20	Sheet no.: 4/5
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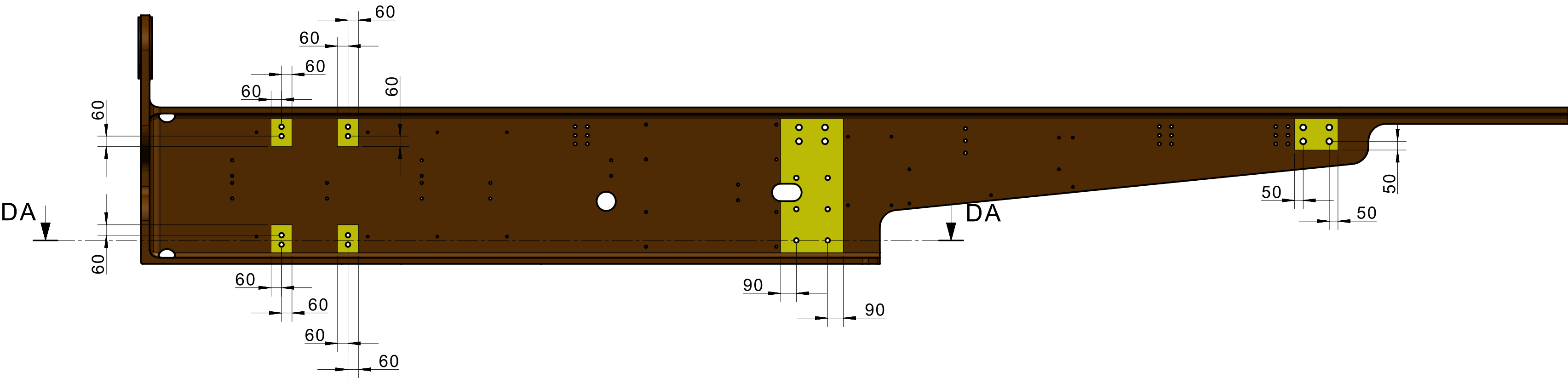
富都机械

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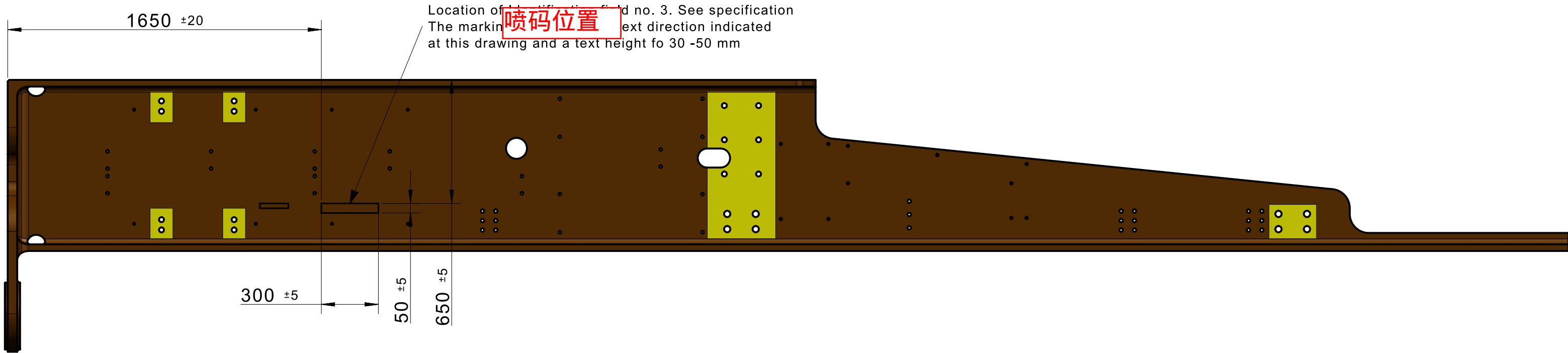
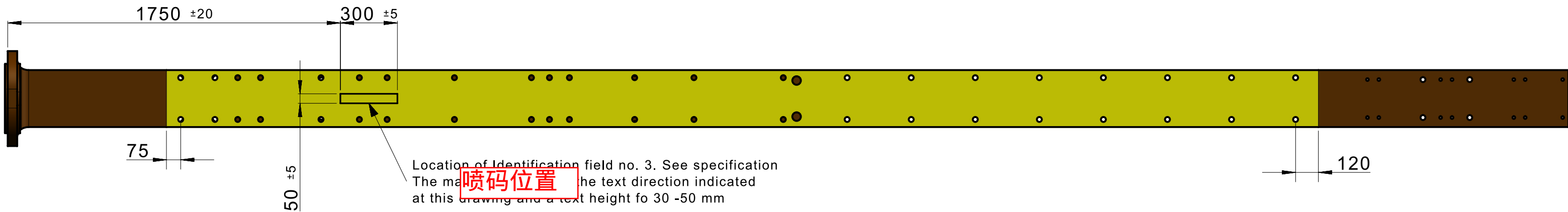
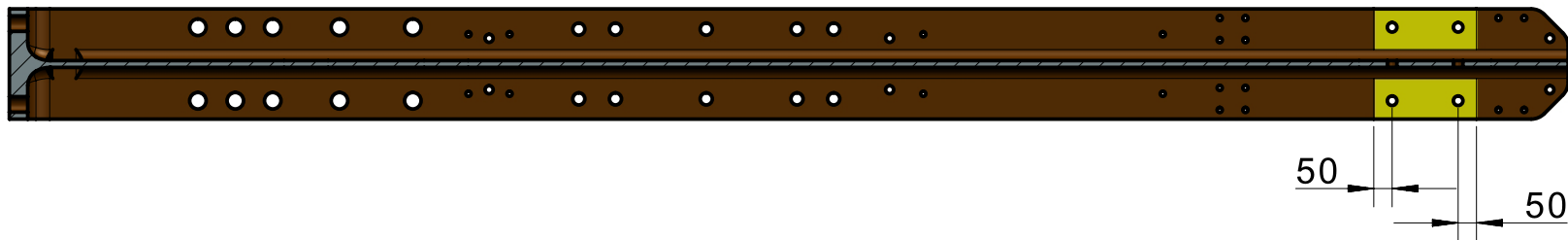
Surface corrosion protection system

Location of reference areas.

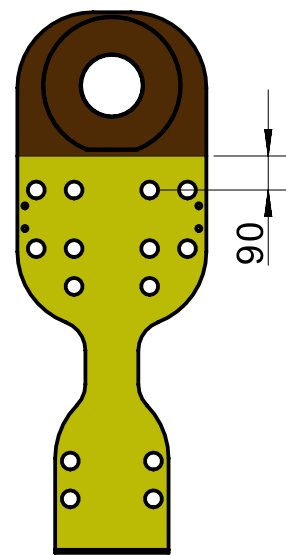
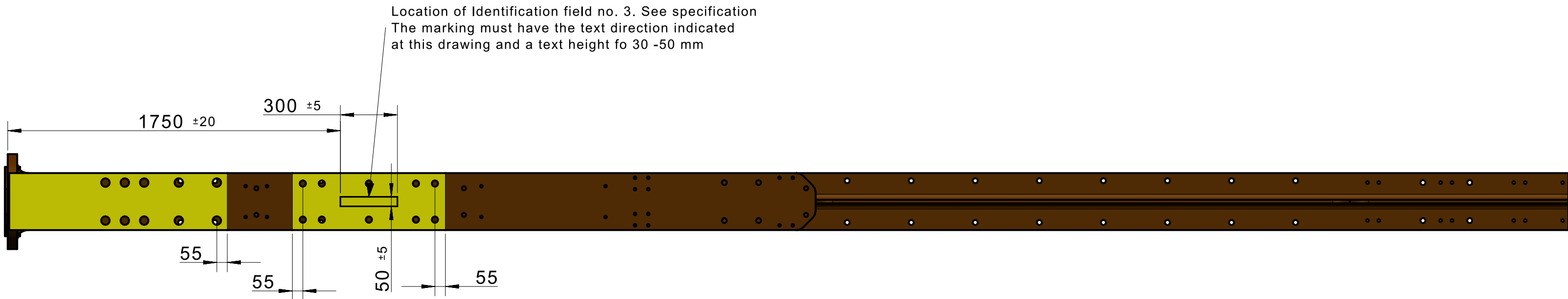
Color:	Used for:
<div></div>	M-1-1
<div></div>	M-1-2



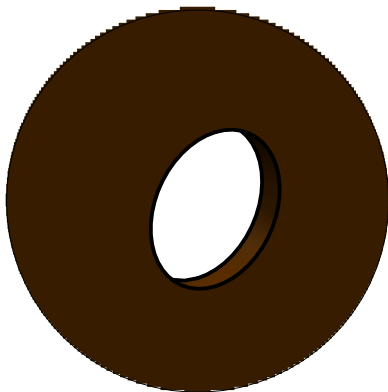
DA-DA (1:20)



喷码位置



DB (1:5)
For both cut-outs



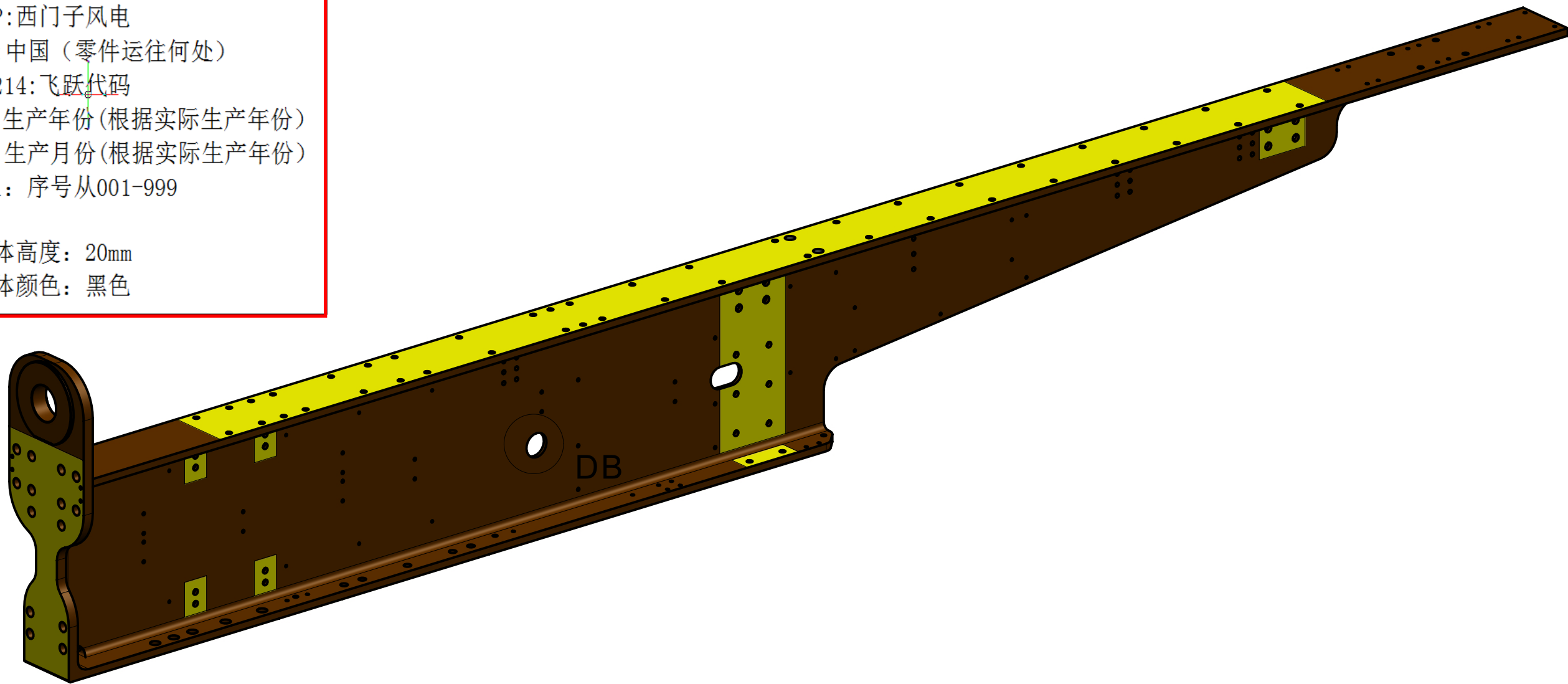
通用要求：
1.清洁度Sa3
2.粗糙度85-130um
3.所有自由边倒角R2
M-1-1：法兰接触面。热喷锌，膜厚60-160um
M-1-2：C4要求。热喷锌，膜厚90um

喷码要求(上海电气)：

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01: 生产月份(根据实际生产年份)
001: 序号从001-999

字体高度：20mm
字体颜色：黑色



Unspecified tolerances: ±5 mm.

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Weight app.: 1970.4 kg		Proprietary class: Restricted		EC 3	
Part: Main beam for Rear End D6 - 7,0		Draw. format: A1	ISO 	Draw. scale: 1:20	Sheet no.: 5/5
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